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Meat and Poultry Inspection Program

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PROCUREMENT SECTION
CURRENT SERIAL RECORDS
CONTENTS

NOV 11 '76

U.S. DEPT. OF AGRICULTURE
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CFR Amendment (Proposal)
Canning of Meat and Poultry
Products

MPI Bulletin
76-160, Checklist of MPI
Bulletins and Directives

Changes
76-10, Meat and Poultry
Inspection Manual

76-10, Meat and Poultry
Inspection Regulations

UNITED STATES DEPARTMENT OF AGRICULTURE
Animal and Plant Health Inspection Service
Meat and Poultry Inspection Program
Washington, D.C. 20250

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October 18, 1976

PROPOSAL

**Animal and Plant Health Inspection Service
[9 CFR Parts 301, 318, 320, 327 and 381]**

**CANNING OF MEAT AND POULTRY
PRODUCTS**

Updating of Inspection Requirements

Pursuant to the authority contained in the Federal Meat Inspection Act, as amended (21 U.S.C. 601 et seq.), and in the Poultry Products Inspection Act, as amended (21 U.S.C. 451 et seq.), notice is hereby given in accordance with the administrative procedure provisions in 5 U.S.C. 553 that the Animal and Plant Health Inspection Service is considering amending Parts 301, 318, 320, and 327 of the Federal meat inspection regulations (9 CFR Parts 301, 318, 320, and 327), and Part 381 of the poultry products inspection regulations (9 CFR Part 381) to update its inspection requirements concerning canned meat and poultry products.

Statement of considerations. These proposed regulation changes would modernize the existing canning regulations over meat and poultry in accordance with advances in industry practice, strengthen regulatory control in areas where need has been indicated by inspection experience, and present the requirements in clearer and more specific detail than has been done previously. In addition, inspection regulations covering canning will be made nearly identical for meat and poultry products. A few of the older methods of control will be discarded since they are no longer appropriate in light of technological and other changes. The proposal will define the various categories of canned product. It would require that canning be performed in a sanitary environment, using sanitary equipment and facilities, and that the operation be properly monitored for safety. The presence and proper functioning of monitoring instruments will be stressed as crucial factors necessary to insure product safety and stability.

The proposal would require that process schedules for canned products be established by qualified persons having expert knowledge of thermal processing requirements who have adequate facilities at their immediate disposal for making such determinations. In order to insure a good control regime, the proposal would require the submission of a schedule of complete processing procedures to the inspection Program prior to their use in manufacture. This is to give Federal inspectors the opportunity to check any procedures before they are used. Once established, such procedures must be strictly adhered to.

The proposal would allow for the preparation of properly marked product in cans which require refrigeration—so-called pasteurized product. Similarly, it will allow for the preparation of "acidified products," a procedure which relies primarily upon factors other than heat for product safety.

The proposal spells out other industry responsibilities. For example, it would require that trained container closure and retort supervisors be present during operations to properly supervise these vital areas of the canning process. Further, it would require examination of containers after closing to check the closing machine for proper function and, in addition, specifies how often this should be done. It would provide that containers shall be properly heat processed after closing to prevent microbiological growth and consequent deterioration in the wholesomeness and shelf life of the food product. It would require that retort baskets and similar containers be tagged with a marker that will change color after heat processing or be identified by some other means to assure positively that all cans receive proper heat processing. Also, retorts must be supplied with recording thermometers as well as properly designed mercury-in-glass thermometers so that a record can be made of the temperatures and cooking times used during processing—vital information in determining product safety and stability. To insure that the data collected is accurate, the proposal would require that thermometers and pressure gauges be periodically checked for function and accuracy and that the findings be recorded by the establishments.

The proposal calls for use of chlorine in cooling water to prevent introduction of contamination through wet can seams which would lead to subsequent damage to the contents of the container. Canning establishments would also be required to conduct a scientifically designed, condition-of-container inspection prior to shipment of product from the plant. If defective cans are found as a result of this inspection, retention of products prepared by similar processes to that used in the preparation of defective cans will be mandatory. Such shipments will not be released until the cause of the defect is determined and corrected.

The proposal would provide for the production of high acid products without heat processing or incubation. The maximum pH value for this type of product has been changed from 4.5 to 4.6 in accordance with recent studies that have shown that this slight decrease in acidity does not permit growth of *Clostridium botulinum* and other bacteria which could cause botulism and other forms of food poisoning.

A portion of this proposal dealing primarily with incubation was published in the FEDERAL REGISTER for public comment on April 17, 1973. Some worthwhile new information was obtained from that publication and has been incorporated accordingly into this more comprehensive proposal.

Following publication of the proposal in 1973, 10 comments were received. Eight of these comments originated from individual canners and two were received from canning associations.

batch and are not moved through the retort.

(4) "Continuous retort" means a retort in which cans are heat processed as they move through the retort.

(5) "Closure head" means a part of a closing machine which clamps the can lid to the body of the can.

(6) "Heat processing" or "thermal processing" means the exposure of products to sufficient heat to render them sufficiently free of both pathogenic organisms and spoilage organisms so that they will remain stable and safe under the designated conditions of storage and handling.

(7) "Underprocessed" means product that has not received that degree of heat processing proposed by the establishment and by the Program inspector as the minimum required for stability and safety under the designated terms and conditions of storage.

(8) "Product safety and stability" means the combination of characteristics which maintain the product in an unadulterated state under the designated conditions of storage and handling.

(9) "Low acid" means having a pH greater than 4.6.

(10) "Tear-down examination" means the examination of a can seam after exposure of a cross section of the double seam used in its closure.

PART 318—ENTRY INTO OFFICIAL ESTABLISHMENTS; REINSPECTION AND PREPARATION OF PRODUCTS

2. In the Table of Contents relating to Part 318, the section heading for § 318.11 would be amended and the revised section would read as follows:

§ 318.11 Canning; definition; facilities and equipment; processing procedures; employees; cleaning containers; closure; heat processing; identification; marking; monitoring instruments; container inspection; rework; and incubation.

(a) Canned product as referred to in this section shall include any thermally processed product packaged in a rigid, semi-rigid, or flexible container of glass, metal, or other material and hermetically sealed to produce a shelf-stable product when stored at a temperature above 50° F; or any product which is packaged in such a hermetically sealed container and so processed to make it safe and stable when held continuously under refrigeration at or below 50° F; or a high acid product. A high acid product as used in this paragraph is a product in which each component has a pH value of 4.6 or below as measured immediately after processing and which is packaged in a rigid, semi-rigid or flexible container, with or without thermal processing after closure.

(b) Equipment and facilities for processing canned product shall be adequate in design and capacity for intended purposes, maintained in good working order, and kept in a sanitary condition at all

The original proposal allowed for a plus or minus 2° F temperature variation within the incubator. A variation of plus or minus 5° F is now proposed as it is considered adequate for safety and more practical under field conditions. The original proposal also required new products to have a satisfactory 20-day incubation history for 250 production days before the incubation period could be reduced to 10 days. Considering the warehousing burden presented by this longer period and the fact that many products are produced so infrequently that it might take many years to obtain the necessary satisfactory production days, the Program proposes to consider 30 production days as adequate to insure

safety of the new process. Such a schedule would be maintained provided the subsequent 180 marketing days prove satisfactory. We believe this approach to be more practicable and it will still provide the consumer assurance that he is purchasing a wholesome product. The original proposal also included a provision for increased incubation periods for products composed of chunks or patties of meat or poultry in a medium or sauce, with a pH value variation between the meat or poultry and the sauce or medium; and also increased incubation periods for samples of firmly packed poultry products. These requirements were deleted in light of the strengthened processing controls appearing for the first time in this proposal. Other changes that will appear for the first time in this proposal include slight rewording to clarify the term "fully processed" as it is used in the poultry regulations, to mean more specifically shelf-stable, thermally processed products. Certain recordkeeping requirements are imposed. Also, the incubation requirement that imported canned product be held at 95° F (plus or minus 2° F) will be revised to read that the product be held at 95° F (plus or minus 5° F) to make this requirement consistent with the one imposed upon domestic canned products.

Accordingly, the following amendments of the regulations in 9 CFR, Parts 301, 318, 320, 327, and 381 are proposed:

PART 301—DEFINITIONS

1. Section 301.2 of the meat inspection regulations is amended by adding a new paragraph (ooo) to read as follows:

§ 301.2 Definitions.

(ooo) The following definitions apply only to § 318.11 of this chapter relating to canning:

(1) "Incubation" or "sample incubation" means the holding of a sample(s) at a specified temperature for a specified period of time before examination.

(2) "Retort" means any closed vessel or other equipment used for the thermal processing of food.

(3) "Still retort" means a retort in which the cans are heat processed as a

times. The establishment shall pay particular attention to the proper functioning of monitoring instruments and other equipment which relate directly to product safety and stability.

(c) Process schedules selected for canned product shall receive a satisfactory evaluation by a qualified person recognized by the Administrator as having expert knowledge of thermal processing requirements, and having adequate facilities for making such determinations at his immediate disposal. A process schedule is a description of the thermal process selected for a given product by the establishment as adequate to produce commercially sterilized or pasteurized product as described in paragraphs (c) (1), (2), or (3) of this section.

(1) The process schedules of any product containing a component with a pH value above 4.6 as measured immediately after processing must include, as a minimum, provision for sufficient thermal processing to achieve commercial sterility. Commercial sterility or commercial sterilization of products as used in this paragraph means the condition achieved by application of heat which renders such products free of viable forms of microorganisms having public health significance as well as microorganisms of nonhealth significance capable of reproducing in the products under normal nonrefrigerated conditions of storage and distribution.

(2) When a combination of heat and curing ingredients is relied upon for commercial sterilization of canned products, such product must contain a sufficient concentration of curing ingredients and be processed at such temperatures and for such periods of time as to maintain the wholesomeness of the product when such product is maintained under usual nonrefrigerated conditions of storage and transportation.

(3) If heat is relied upon to achieve pasteurization but not commercial sterilization in any product, the Administrator may permit the products to be processed under such specific time, temperature, and storage conditions, labeling, and formulation requirements as are needed, in his determination, to maintain product safety and stability.

(d) Canned products which do not rely upon heating for preservation shall be prepared under such conditions of acidity, brine concentration, dehydration, and the like as the Administrator determines are required to maintain product safety and stability.

(e) Prior to the manufacture of any canned product identified in paragraphs (c) and (d) of this section, a complete processing procedure for each product in each container size shall be submitted in duplicate by the establishment to the inspector in charge. A complete processing procedure shall include a detailed formulation, a step-by-step description of the method of manufacture, a process schedule if thermal treatment is used for

product preservation, and such other information as is pertinent to compliance with the requirements of this section. The filing for acceptance of such information, however, does not constitute approval of the procedure by the Program. The Program reserves the right to comment on the adequacy of the procedure at any time. Once submitted, the processing procedures shall not be changed without submittal of the revised processing procedure to the inspector in charge. Revised process schedules must also receive satisfactory evaluation by qualified persons having expert knowledge of the processing requirements of such products.

(f) Establishments shall assign competent and trained employees to canning operations in the number needed to insure strict adherence to processing procedures submitted in accordance with paragraph (e) of this section. At least one closure supervisor and one retort supervisor (who may be the same person), certified by the establishment as having attended a training program approved by the Administrator, shall be on duty during all hours of operation of each establishment when it is preparing thermally processed, low acid meat products packaged in hermetically sealed containers.

(g) All containers shall be thoroughly cleaned before filling. Containers may be cleaned with water, vacuum, or a jet stream device so that the entire inner surface of the containers is well drained and free from any soilage at the time of filling. Subsequent soiling of the inner surfaces must be avoided. Lids and pouches and the like which are enclosed in their original wrapping and are clean and sanitary, in the opinion of the Program employee, need not be washed or sprayed before use. Plant management shall examine such containers and lids for cleanliness prior to the start of operations and a minimum of once every hour thereafter during operations.

(h) Immediately following closure, a representative of the establishment shall visually examine one container for each closure head or a similar representative number of containers for closure defects. These examinations shall be conducted at intervals not to exceed 30 minutes. Any closure deviation requiring correction must be brought to the immediate attention of the designated closure supervisor. When closure defects are reported, the establishment shall reinspect containers produced since the last satisfactory closure examination for defects and take appropriate corrective action immediately. Records shall be maintained and made available at all times for review by the Program inspector. Records of these examinations shall include time, number of cans examined, nature of defects, and corrective action taken.

(i) Unless otherwise approved by the Administrator in specific cases, heat processing shall follow promptly after

closing. The maximum time lapse between closing and initiation of heat processing shall be 1 hour, but the Program may specify a shorter period of time if the temperature of the product during canning or the nature of the product so warrants such action.

(j) Canned product in the retort area shall be identified prior to, during, and after heat processing by tagging the baskets, cages, or cans with an identification device that will change color upon undergoing heat processing, or by other effective means so as to positively preclude failure to heat process after closing.

(k) All containers of canned product shall be plainly and permanently marked, by code or otherwise, with the identity of the contents and the date of canning. The code used and its meaning shall be on record in the office of the Inspector in charge. If calendar dating is used, it must be accompanied by an explanatory statement, as provided in § 317.8(b) (32) (ii) of this chapter.

(l) All operating retorts, both still and continuous, shall be supplied with working, accurate, mercury-in-glass thermometers and with recording thermometers.

(m) All monitoring instruments such as pressure gauges and thermometers must be checked periodically for function and accuracy by a qualified establishment employee and maintenance records must be logged and available at all times for review by inspectors.

(n) The establishment shall monitor the processing times and temperatures required by the stated procedures to insure that the procedure is being correctly followed and shall maintain all time and temperature records. These records must be available at all times for review by the Program inspector.

(o) Cooling water, except that used in retorts or cookers, must contain a minimum residual chlorine level of one part per million, in order to prevent contamination of products through wet can seams.

(p) The establishment shall perform comprehensive closure examinations of containers, including tear-down examinations for double seam containers, at least once every 4 hours to insure that operations are within the tolerances required, as determined by the Program inspector, to maintain product safety and stability. In making such determination, the inspector shall consider the seam tolerances recommended by the container or closing machine suppliers. The establishment shall maintain records of these examinations and keep them available at all times for review by the Program inspector. Appropriate adjustments to the closing machine shall be taken as necessary to provide for the safety and stability of the product.

(1) Tear-down examinations for double seam cans shall include:

(i) If a micrometer measurement system is used: Three measurements shall

be made at points approximately 120° apart, excluding the side seam, for each double seam characteristic. The double seam characteristics to be measured are cover hook, body hook, and width (length, height), tightness; or,

(ii) If a seam scope or projector is used: Two measurements shall be made at different locations, excluding the side seam, for each double seam characteristic. The double seam characteristics to be measured are body hook, overlap, and tightness.

(2) For closures other than double seams, appropriate tests shall be conducted in accordance with the recommendations of the container or closing machine suppliers.

(q) After final labeling, the establishment shall perform a condition-of-container examination in which a sample of individual cans are visually examined to determine if the integrity of the can is sufficient to maintain the safety and stability of the canned product. The condition-of-container inspection criteria used by the Program inspector to make his determination of the adequacy of containers at this point shall be made freely available for establishment use if desired. However, should the establishment desire to use another examination, substantially equivalent to that of the Program, it shall be submitted to the Administrator for approval. Such application shall include a range of lot sizes, a sample size for each range, control limits, and such other information as the Administrator may require to determine the adequacy of the plan. No canned product shall leave the establishment if found to be unsatisfactory with regard to condition of containers, until it has been sorted, re-examined, and determined to be satisfactory.

(r) If, upon incubation, or for any other reason a product is suspected of being, or determined to be underprocessed, appropriate corrective action, including recall of defective lots, must be taken to assure that only wholesome product reaches the consumer. The circuit supervisor may permit lots of canned product to be shipped from the official establishment prior to completion of sample incubation when he has no reason to suspect unsoundness in the particular lots, under circumstances which will assure the return of the product to the establishment for reinspection, should such action be indicated by the incubation results.

(s) If defective containers are found within the establishment, all canned product prepared by a similar process shall be retained, or if located outside the official establishment, they shall be detained, until the nature and extent of the defective condition is fully determined and appropriate corrections are made.

(t) Reworking of product resulting from insufficient or interrupted processing must be accomplished under suffi-

cient safeguards of time and temperature to assure that only wholesome product is reused. Proposals for the reworking of product shall be submitted to the inspector in charge for approval before implementation.

(u) Facilities shall be provided by the operator of the official establishment for the incubation of representative samples of thermally processed, shelf-stable products packaged in hermetically sealed containers. The incubation shall consist of holding samples for such periods of time and at such temperatures as are prescribed in paragraphs (u) (1) and (3) of this section.

(1) Incubation tests shall be made to the extent required by the circuit supervisor, but in no cases for periods of time less than those specified in paragraph (u) (3) of this section. The extent to which incubation tests shall be required depends upon the conditions at the official establishment, such as the record of the official establishment in conducting canning operations, the extent to which the establishment furnishes competent supervision and inspection in connection with the canning operation, the kind of equipment used, and the degree of efficiency with which such equipment is maintained.

(2) In the event of failure by an official establishment to provide suitable facilities for incubation of test samples, the circuit supervisor may require holding of the entire lot from which the sample originated under such conditions and for such period of time as he deems necessary to establish the safety and stability of the product.

(3) Products in which all components have a pH value of 4.6 or below, as measured immediately after processing, do not require incubation. The means used to measure pH must be sufficiently reliable to insure the safety and stability of the product as determined by the Administrator.¹ Establishments shall maintain a pH control program approved by the Administrator as adequate, if properly used, to assure product safety and stability. Approval may be obtained by application to the Regional Director, stating the pH range and the frequency of the checking procedures. The range must be sufficiently controlled to assure product safety and stability. The frequency of checking shall, at minimum, be once every other batch or twice in an 8-hour day, whichever is more frequent. If the inspector determines upon inspection that the pH range is not in compliance, he shall retain production of that product until the pH control program can again function as approved. All product not in compliance shall be retained until

¹ A list of all such approved means of measurement shall be maintained by the Administrator and be made available to the public upon request.

it is brought into compliance or condemned if it is determined by a Program employee to be adulterated. Samples of product shall be incubated at 95° F. (plus or minus 5° F) as follows:

(i) Products containing any component which has a pH value above 4.6, as measured immediately after processing, shall be incubated for not less than 10 days.

(ii) New products (or product prepared under a new process) with a pH value above 4.6, as measured immediately after processing, shall be incubated for not less than 20 days. The incubation period for such products may be reduced to not less than 10 days when satisfactory incubation testing of 30 production days (or shift) indicates that the thermal processing used is adequate to insure product safety and stability. However, if the subsequent 180-day market history is not satisfactory, an incubation cycle as for a new product shall be reinstated immediately.

(iii) Sausages of the chorizos type packed in lard shall be incubated for not less than 20 days.

PART 320—RECORDS, REGISTRATION, AND REPORTS

3. Section 320.1, paragraph (b) of the meat inspection regulations would be amended by adding new paragraph (b) (5) to read as follows:

§ 320.1 Records required to be kept.

* * * *

(b) * * *

(5) Records as required by § 318.11 of this chapter.

4. Section 320.3 of the meat inspection regulations would be amended by designating the existing text as paragraph (a) and adding a new paragraph (b) to read as follows:

§ 320.3 Record retention period.

* * * *

(b) Copies of all records required by § 318.11 shall be maintained at the establishment for a period of not less than 3 years.

PART 327—IMPORTED PRODUCTS

§ 327.6 [Amended]

5. In § 327.6, paragraph (k), subparagraph (1), the incubation temperature shown at the end of the first sentence would be changed to read "95° F (plus or minus 5° F)".

PART 381—POULTRY PRODUCTS INSPECTION REGULATIONS

6. Section 381.1 of the poultry products inspection regulations is amended by adding a new paragraph (d) to read as follows:

§ 381.1 Definitions.

* * * *

(d) The following definitions apply only to § 381.149 relating to canning:

(1) "Incubation" or "sample incubation" means the holding of a sample(s) at a specified temperature for a specified period of time before examination.

(2) "Retort" means any closed vessel or other equipment used for the thermal processing of food.

(3) "Still retort" means a retort in which the cans are heat processed as a batch and are not moved through the retort.

(4) "Continuous retort" means a retort in which cans are heat processed as they move through the retort.

(5) "Closure head" means a part of a closing machine which clamps the can lid to the body of the can.

(6) "Heat processing" or "thermal processing" means the exposure of products to sufficient heat to render them sufficiently free of both pathogenic organisms and spoilage organisms so that they will remain stable and safe under the designated conditions of storage and handling.

(7) "Underprocessed" means product that has not received that degree of heat processing proposed by the establishment and by the Program inspector as the minimum required for stability and safety under the designated terms and conditions of storage.

(8) "Product safety and stability" means the combination of characteristics which maintain the product in an unadulterated state under the designated conditions of storage and handling.

(9) "Low acid" means having a pH greater than 4.6.

(10) "Tear-down examination" means the examination of a can seam after exposure of a cross section of the double seam used in its closure.

7. In the Table of Contents relating to Subpart O, Part 381, the section heading for § 381.149 would be amended and the revised section would read as follows:

§ 381.149 Canning; definition; facilities and equipment; processing procedures; employees; cleaning containers; closure; heat processing; identification; marking; monitoring instruments; container inspection; rework; and incubation.

(a) Canned product as referred to in this section shall include any thermally processed product packaged in a rigid, semi-rigid, or flexible container of glass, metal, or other material and hermetically sealed to produce a shelf-stable product when stored at a temperature above 50° F; or any product which is packaged in such a hermetically sealed container and so processed to make it safe and stable when held continuously under refrigeration at or below 50° F; or a high acid product. A high acid product as used in this paragraph is a product in which each component has a pH value of 4.6 or below as measured im-

mediately after processing and which is packaged in a container with or without thermal processing after closure.

(b) Equipment and facilities for processing canned product shall be adequate in design and capacity for intended purposes, maintained in good working order, and kept in a sanitary condition at all times. The establishment shall pay particular attention to the proper functioning of monitoring instruments and other equipment which relate directly to product safety and stability.

(c) Process schedules selected for canned product shall receive a satisfactory evaluation by a qualified person recognized by the Administrator as having expert knowledge of thermal processing requirements, and having adequate facilities for making such determinations at his immediate disposal. A process schedule is a description of the thermal process selected for a given product by the establishment as adequate to produce commercially sterilized or pasteurized product, as described in paragraph (c) (1), (2), or (3) of this section.

(1) The process schedules of any product containing a component with a pH value above 4.6, as measured immediately after processing, must include, as a minimum, provision for sufficient thermal processing to achieve commercial sterility. Commercial sterility or commercial sterilization of products as used in this paragraph means the condition achieved by application of heat which renders such products free of variable forms of micro-organisms having public health significance as well as micro-organisms of nonhealth significance capable of reproducing in the products under normal nonrefrigerated conditions of storage and distribution.

(2) When a combination of heat and curing ingredients is relied upon for commercial sterilization of canned products, such products must contain a sufficient concentration of curing ingredients and be processed at such temperatures and for such periods of time as to maintain the wholesomeness of the product when such product is maintained under usual nonrefrigerated conditions of storage and transportation.

(3) If heat is relied upon to achieve pasteurization but not commercial sterilization in any product, the Administrator may permit the products to be processed under such specific time, temperature, and storage conditions, labeling, and formulation requirements as are needed, in his determination, to maintain product safety and stability.

(d) Canned products which do not rely upon heating for preservation shall be prepared under such conditions of acidity, brine concentration, dehydration, and the like as the Administrator determines are required to maintain product safety and stability.

(e) Prior to the manufacture of any canned product identified in paragraphs

(c) and (d) of this section, a complete processing procedure for each product in each container size shall be submitted in duplicate by the establishment to the inspector in charge. A complete processing procedure shall include a detailed formulation, a step-by-step description of the method of manufacture, a process schedule if thermal treatment is used for product preservation, and such other information as is pertinent to compliance with the requirements of this section. The filing of such information, however, does not constitute approval of the procedure by the Program. The Program reserves the right to comment on the adequacy of the procedure at any time. Once submitted, the processing procedures shall not be changed without submittal of the revised processing procedure to the inspector in charge. Revised process schedules must also receive satisfactory evaluation by qualified persons having expert knowledge of the processing requirements of such products.

(f) Establishments shall assign competent and trained employees to canning operations in the number needed to insure strict adherence to processing procedures submitted in accordance with paragraph (e) of this section. At least one closure supervisor and one retort supervisor (who may be the same person), certified by the establishment as having attended a training program approved by the Administrator, shall be on duty during all hours of operation of each establishment when it is preparing thermally processed, low acid poultry products packaged in hermetically sealed containers.

(g) All containers shall be thoroughly cleaned before filling. Containers may be cleaned with water, vacuum, or a jet stream device so that the entire inner surface of the containers is well drained and free from any soilage at the time of filling. Subsequent soiling of the inner surfaces must be avoided. Lids and pouches and the like which are enclosed in their original wrapping and are clean and sanitary in the opinion of the Program employee, need not be washed or sprayed before use. Plant management shall examine such containers and lids for cleanliness prior to the start of operations and a minimum of once every hour thereafter during operations.

(h) Immediately following closure, a representative of the establishment will visually examine one container for each closure head, or a similar representative number of containers for closure defects. These examinations shall be conducted at intervals not to exceed 30 minutes. Any closure deviation requiring correction must be brought to the immediate attention of the designated closure supervisor. When closure defects are reported, the establishment shall reinspect containers produced since the last satisfactory closure examination for defects

and take appropriate corrective action immediately. Records shall be maintained and made available at all times for review by the Program inspector. Records of these examinations shall include time, number of cans examined, nature of defects, and corrective action taken.

(i) Unless otherwise approved by the Administrator in specific cases, heat processing shall follow promptly after closing. The maximum time lapse between closing and initiation of heat processing shall be 1 hour, but the Program may specify a shorter period of time if the temperature of the product during canning or the nature of the product so warrants such action.

(j) Canned product in the retort area shall be identified prior to, during, and after heat processing by tagging the baskets, cages, or cans with an identification device that will change color upon undergoing heat processing, or by other effective means so as to positively preclude failure to heat process after closing.

(k) All containers of canned product shall be plainly and permanently marked, by code or otherwise, with the identity of the contents and the date of canning. The code used and its meaning shall be on record in the office of the inspector in charge. If calendar dating is used, it must be accompanied by an explanatory statement, as provided in § 381.129(c)(2).

(l) All operating retorts, both still and continuous, shall be supplied with working, accurate, mercury-in-glass thermometers and with recording thermometers.

(m) All monitoring instruments such as pressure gauges and thermometers must be checked periodically for function and accuracy by a qualified establishment employee and maintenance records must be logged and available at all times for review by inspectors.

(n) The establishment shall monitor the processing times and temperatures required by the stated procedures to insure that the procedure is being correctly followed and shall maintain all time and temperature records. These records must be available at all times for review by the Program inspector.

(o) Cooling water, except that used in retorts or cookers, must contain a minimum residual chlorine level of one part per million, in order to prevent contamination of products through wet can seams.

(p) The establishment shall perform comprehensive closure examinations of containers, including tear-down examinations for double seam containers, at least once every 4 hours to insure that operations are within the tolerances required, as determined by the Program inspector, to maintain product safety and stability. In making such determination, the inspector shall consider the

seam tolerances recommended by the container or closing machine suppliers. The establishment shall maintain records of these examinations and keep them available at all times for review by the Program inspector. Appropriate adjustments to the closing machine shall be taken as necessary to provide for the safety and stability of the product.

(1) Tear-down examinations for double seam cans shall include:

(i) If a micrometer measurement system is used: Three measurements shall be made at points approximately 120° apart, excluding the side seam for each double seam characteristic. The double seam characteristics to be measured are cover hook, body hook, and width (length, height), tightness; or,

(ii) If a seam scope or projector is used: Two measurements shall be made at different locations, excluding the side seam, for each double seam characteristic. The double seam characteristics to be measured are body hook, overlap, and tightness.

(2) For closures other than double seams, appropriate tests shall be conducted in accordance with the recommendations of the container or closing machine suppliers.

(q) After final labeling, the establishment shall perform a condition-of-container examination in which a sample of individual cans are visually examined to determine if the integrity of the can is sufficient to maintain the safety and stability of the canned product. The condition-of-container inspection criteria used by the Program inspector to make his determination of the adequacy of containers at this point shall be made freely available for establishment use if desired. However, should the establishment desire to use another examination, substantially equivalent to that of the Program, it shall be submitted to the Administrator for approval. Such application shall include a range of lot sizes, a sample size for each range, control limits, and such other information as the Administrator may require to determine the adequacy of the plan. No canned product shall leave the establishment if found to be unsatisfactory with regard to condition of containers, until it has been sorted, re-examined, and determined to be satisfactory.

(r) If, upon incubation, or for any other reason product is suspected of being, or determined to be underprocessed, appropriate corrective action, including recall of defective lots, must be taken to assure that only wholesome product reaches the consumer. The circuit supervisor may permit lots of canned product to be shipped from the official establishment prior to completion of sample incubation when he has no reason to suspect unsoundness in the particular lots, under circumstances which

will assure the return of the product to the establishment for reinspection, should such action be indicated by the incubation results.

(s) If defective containers are found within the establishment, all canned product prepared by a similar process shall be retained, or if located outside the official establishment, they shall be detained, until the nature and extent of the defective condition is fully determined and appropriate corrections are made.

(t) Reworking of product resulting from insufficient or interrupted processing must be accomplished under sufficient safeguards of time and temperature to assure that only wholesome product is reused. Proposals for the reworking of product shall be submitted to the inspector in charge for approval before implementation.

(u) Facilities shall be provided by the operator of the official establishment for the incubation of representative samples of thermally processed, shelf-stable products packaged in hermetically sealed containers. The incubation shall consist of holding samples for such periods of time, and at such temperatures as are prescribed in paragraphs (u) (1) and (3) of this section.

(1) Incubation test shall be made to the extent required by the circuit supervisor, but in no cases for periods of time less than those specified in paragraph (u) (3) of this section. The extent to which incubation tests shall be required depends upon the conditions at the official establishment, such as the record of the official establishment in conducting canning operations, the extent to which the establishment furnishes competent supervision and inspection in connection with the canning operation, the kind of equipment used, and the degree of efficiency with which such equipment is maintained.

(2) In the event of failure by an official establishment to provide suitable facilities for incubation of test samples, the circuit supervisor may require holding of the entire lot from which the sample originated under such conditions and for such period of time as he deems necessary to establish the safety and stability of the product.

(3) Products in which all components have a pH value of 4.6 or below, as measured immediately after processing, do not require incubation. The means used to measure pH must be sufficiently reliable to insure the safety and stability of the product as determined by the Administrator.¹ Establishments shall maintain a pH control program approved by the Administrator as adequate, if properly used, to assure product safety and stability.

Approval may be obtained by application to the Regional Director, stating the

¹ A list of all such approved means of measurement shall be maintained by the Administrator and be made available to the public upon request.

pH range and the frequency of the checking procedures. The range must be sufficiently controlled to assure product safety and stability. The frequency of checking shall, at minimum, be once every other batch or twice in an 8-hour day, whichever is more frequent. If the inspector determines upon inspection that the pH range is not in compliance, he shall retain production of that product until the pH control program can again function as approved. All product not in compliance shall be retained until it is brought into compliance or condemned if it is determined by a Program employee to be adulterated. Samples of product shall be incubated at 95° F (plus or minus 5° F) as follows:

(i) Products containing any component which has a pH value above 4.6 as measured immediately after processing, shall be incubated for not less than 10 days.

(ii) New products (or product prepared under a new process) with a pH value above 4.6, as measured immediately after processing, shall be incubated for not less than 20 days. The incubation period for such products may be reduced to not less than 10 days when satisfactory incubation testing of 30 production days (or shifts) indicates that the thermal processing used is adequate to insure product safety and stability. However, if the subsequent 180-day market history is not satisfactory, an incubation cycle as for a new product shall be reinstated immediately.

8. In the Table of Contents relating to Part 381, the section heading for § 381.126 would be amended to read as follows:

Sec.
381.126 Date of processing.

9. Section 381.126 of the poultry products inspection regulations would be amended by deleting paragraph 381.126 (c), designating § 381.126(d) as § 381.126(c), and revising the section heading which would read as follows:

§ 381.126 Date of processing.

10. Section 381.175, paragraph (b) of the poultry products inspection regulations would be amended by adding new paragraph (b) (3) to read as follows:

§ 381.175 Records required to be kept.

* * *

(b) * * *

(3) Records as required by § 381.149 of this part.

11. Section 381.177 of the poultry products inspection regulations would be amended by designating the existing text as paragraph (a) and adding a new paragraph (b) to read as follows:

§ 381.177 Record retention period.

* * *

(b) Copies of all records required by § 381.149 shall be maintained at the establishment for a period of not less than 3 years.

Any person wishing to submit written data, views, or arguments concerning the proposed amendments may do so by filing them, in duplicate, with the Hearing Clerk, U.S. Department of Agriculture, Washington, D.C. 20250, or if the material is deemed to be confidential, with the Inspection Standards and Regulations Staff, Scientific and Technical Services, Meat and Poultry Inspection Program, Animal and Plant Health Inspection Service, U.S. Department of Agriculture, Washington, D.C. 20250, by January 15, 1977.

Any person desiring opportunity for oral presentation of views should address such requests to the Staff identified in the preceding paragraph, so that arrangements may be made for such views to be presented prior to the date specified in the preceding paragraph. A record will be made of all views orally presented.

All written submissions and records of oral views made pursuant to this notice will be made available for public inspection in the Office of the Hearing Clerk during regular hours of business, unless the person makes the submission to the Staff identified in the preceding paragraph and requests that it be held confidential. A determination will be made whether a proper showing in support of the request has been made on grounds that its disclosure could adversely affect any person by disclosing information in the nature of trade secrets or commercial or financial information obtained from any person which is privileged or confidential. If it is determined that a proper showing has been made in support of the request, the material will be kept confidential; otherwise, notice will be given of denial of such request and an opportunity afforded for withdrawal of the submission. Requests for confidential treatment will be kept confidential (7 CFR 1.27(c)).

Comments on the proposal should bear a reference to the date and page number of this issue of the *FEDERAL REGISTER*.

Done at Washington, D.C., on: September 9, 1976.

HARRY C. MUSSMAN,
Acting Administrator, Animal and
Plant Health Inspection Service.

[FR Doc.76-27169 Filed 9-16-76;8:45 am]

INFORMATION FOR: MPI Employees and Interested Parties

CHECKLIST OF MPI BULLETINS AND DIRECTIVES

July - October 1976

This checklist is issued to aid users in checking receipt of applicable MPI bulletins and directives, and to cancel those that are obsolete. Distribution codes are shown on the bottom of the first page of the issuance. Based on these codes, users may determine if applicable issuances were received. For codes, see MPI Directive 130.1, Rev. 1, Exhibit D, Mailing List Codes Used to Distribute MPI Issuances. If a particular issuance was not received, write to the Printing and Distribution Section, Administrative Services Division, APHIS, USDA, Room 725-A, Federal Building, Hyattsville, MD 20782.

ISSUANCES PUBLISHED

Directives					
Number Date	Subject	Distrib. Code			
910.2 6/29/76	Review of State Meat and Poultry Compliance Programs	A-O,P,Q, U-2	76-109 6/29/76	Imported 12 Oz. Canned Corned Beef Product of Argentina, Est. 1930, Vizental Y Cia	A-O,P,Q, S
915.3 Rev. 1 9/7/76	Reviewing Custom Operations Purportedly Exempt from Inspection Under the Federal Meat Inspection Act and "At Least Equal" State Laws	A-O,P,Q, U-2	76-110 6/29/76	Exports to South Korea	A-O,P,Q, S,U
			76-111 7/6/76	Preparation of Mechanically Deboned Meat, Mechanically Deboned Meat for Processing, Mechanically Deboned Meat for Rendering, Low Temperature Rendered Meat, and Low Temperature Rendered Meat for Processing	A-O,P,Q, S,U,U-2
Bulletins					
Number Date	Subject	Distrib. Code			
76-100 6/18/76	Checklist of MPI Bulletins and Directives	Issuances	76-112 7/9/76	Pizza Labels	A-O,P,Q, S,U
76-101 6/17/76	Exports to Portugal	A-O,P,Q, S,U	76-113 7/13/76	Prohibition Against Carrying Firearms	A-O,P,Q, S,T
76-102 6/21/76	Export of Fresh and Processed Poultry to the Federal Republic of Germany	A-O,P,Q, S,U	76-114 7/19/76	Secretarial Relief	A-L
76-103 6/21/76	Use of "Passed for Cooking" Carcasses in Certified Pet Food	A-O,P,Q, S,U	76-115 7/20/76	Correct Zip Code of the Chicago Data Services Center	A-O,P,Q, S
76-104 6/24/76	Lifting Restrictions on Imported Products from Est. 13, Argentina	A-O,P,Q, S	76-116 7/21/76	Tours of Duty	Limited
76-105 6/25/76	Pork Percentage in Certain Meat Food Products	A-O,P,Q, S,U	76-117 7/22/76	Lifting Restrictions on Imported Products from Est. 2, Panama	A-O,P,Q, S
76-106 6/25/76	Submission of Samples for Biological Residue Analysis	A-O,P,Q, S	76-118 7/22/76	Lifting Restrictions on Imported Products from Est. 4, Guatemala	A-O,P,Q, S
76-107 6/29/76	Pay for Sunday Work	A-O,P,Q, S,T	76-119 7/22/76	Lifting Restrictions on Imported Products from Ests. SIF-4 & SIF-7, Brazil	A-O,P,Q,S
76-108 6/29/76	Export of Ground or Comminuted Poultry and Poultry Meat to Japan	A-O,P,Q, S,U	76-120 7/22/76	Exports to Great Britain (United Kingdom)	A-O,P,Q, S
			76-121 7/28/76	Corrections to Form MP-486	A-O,P,Q, S,T

76-122 7/30/76	Export of Meat to the Federal Republic of Germany	A-O,P,Q, S,U	76-141 8/30/76	Export of Fresh and Processed Poultry to the Federal Republic of Germany	A-O,P,Q, S,U
76-123 8/3/76	MPI-APHIS Management and Communication System Coordination	A-O,Q	76-142 9/2/76	Export to France of Edible Product Intended for Animal Food	A-O,P,Q, S,T
76-124 8/5/76	Lifting Restrictions on Imported Products from Est. TIF-24, Mexico	A-O,P,Q, S	76-143 9/1/76	Temporary Restraining Order	A-O,P,Q, S,U,U-2
76-125 8/5/76	Hold and Test Restriction on Imported Product from Est. 13 - Argentina	A-O,P,Q, S	76-144 9/8/76	Chicken Breasts	A-O,P,Q, S,U
76-126 8/5/76	Imports from Establishment 7 - Poland	A-O,P,Q, S,T	76-145 9/8/76	Clarification of Religious (Buddhist) Requirement	A-O,P,Q, S,U,U-2
76-127 8/5/76	Imported 12 Oz. Canned Corned Beef, Product of Argentina, Est. 1930, Vizental Y Cia	A-O,P,Q, S,R	76-146 9/14/76	Mechanically Deboned Meat	A-O,P,Q, S,T,U,U-2
76-128 8/10/76	Reinspection of Young Chickens, Mature Chickens, and Turkeys	A-O,P,Q, S,U	76-147 9/17/76	Inspection of Contract Specification Product	A-O,P,Q, S,T,U
76-129 8/12/76	Imports from Establishment 67, Poland	A-O,P,Q, S	76-148 9/20/76	Imports from Establishment 55, Netherlands	A-O,P,Q, S
76-130 8/12/76	Lifting Restrictions on Imported Products from Est. 7, Guatemala	A-O,P,Q, S	76-149 9/21/76	Lifting of Restrictions on Imported Products from Est. 1, Guatemala	A-O,P,Q, S
76-131 8/16/76	Labeling of Hams	A-O,P,Q, S,T,U-U-2, Issuan-ces	76-150 9/21/76	Exports to Trinidad and St. Lucia	A-O,P,Q, S
76-132 8/16/76	Reinspection of Poultry Necks and Giblets	A-O,P,Q, S,U	76-151 9/22/76	Exports to Yugoslavia	A-O,P,Q, S,U
76-133 8/18/76	Hold and Test Restriction on Imported Product from Est. TIF-40, Mexico	A-O,P,Q, S	76-152 9/23/76	Hold and Test Restriction on Imported Product from Est. 779, Australia	A-O,P,Q, S
76-134 8/23/76	Export of Meat and Meat Products to the United Kingdom	A-O,P,Q, S,U	76-153 9/23/76	Modification of MP Form 408	A-O,P,Q, S,U
76-135 8/23/76	Export of Meat to the Federal Republic of Germany	A-O,P,Q, S,U	76-154 9/29/76	Imports from Establishment 7, Poland	A-O,P,Q, S
76-136 8/25/76	Import Certification	A-O,P,Q, S	76-155 10/5/76	Location of Tuberculosis (TB) Lesions	A-O,P,Q, S
76-137 8/26/76	Echinococcosis Reporting	A-O,P,Q, S	76-156 10/6/76	Low Temperature Rendered Products	A-O,P,Q, S,T,U,U-2
76-138 8/30/76	Invitation by the Food and Drug Administration to Submit Data, Information, and Views on Permitted Uses of Chlorine in Food Processing	A-O,P,Q, S,R,U	76-157 10/8/76	Exports to Great Britian (UK)	A-O,P,Q, S
76-139 8/30/76	Exports to Canada	A-O,P,Q, S,U	76-158 10/8/76	Lifting Restrictions on Imported Product from Est. 3, Guatemala	A-O,P,Q, S
76-140 8/30/76	Export to West Germany (FRG) of Edible Product Intended for Animal Food	A-O,P,Q, S,U	76-159 10/14/76	Hold and Test Restriction on Imported Product from Est. TIF-49, Mexico	A-O,P,Q, S

ISSUANCES DELETED

Bulletins

1973

173, 216, 251, 267, 303, 356, 390, 407, 446, and 505.

1974

603, 656, 760, 764, 787, 791, 811, 865, and 872

1975

75-13, 75-19, 75-31, 75-32, 75-38, 75-51, 75-59, 75-65, 75-67, 75-70, 75-72, 75-94, 75-97, 75-98, 75-106, 75-109, 75-110, 75-125, 75-135, 75-142, 75-143, 75-144, 75-146, 75-147, 75-149, 75-150, 75-159, 75-163, 75-167, 75-169, 75-174, 75-177, 75-179, 75-183, 75-187, and 75-176

1976

76-9, 76-16, 76-28, 76-42, 76-47, 76-49, 76-57, 76-59, 76-64, 76-71, 76-73, 76-76, 76-85, 76-92, 76-94, 76-99, 76-101, 76-104, 76-109, 76-112, 76-117, 76-118, 76-119, 76-124, 76-126, and 76-127



E. Ciolfi
Acting Chief Staff Officer
Issuance Coordination Staff



UNITED STATES DEPARTMENT OF AGRICULTURE
Animal and Plant Health Inspection Service
Meat and Poultry Inspection Program
Washington, D.C. 20250



MEAT AND POULTRY INSPECTION MANUAL

CHANGE: 76-10

Maintenance Instructions

October 1976

Remove Page	Insert Page	Numbered
107 and 108	107, 108, and 108a	76-10
215 and 215a	215 and 215a	76-10
236e thru 238	236e thru 238	76-10
242a thru 244	242a thru 244	76-10

Pen-and-Ink Changes

Page v, line 8, change "OIG" to "OI" and "Office of the Inspector General" to "Office of Investigation."

Page 11, section 6.16, item 1, change on line 6 "Inspector General (OIG)" to "Investigation (OI)," and on line 10 "OIG" to "OI."

Page 11 and 12, section 6.16, items 2 and 3, change "OIG" to "OI."

Page 212, MP Form 410, under other information add "See section 27.19."

Page 214, delete MP Form 412-15.

MPI Directive 910.1, page 8a/7-1-76, line 5, change "32" to "334."

MPI Bulletins Included

Changes on pages 236e, 236g, and 237 delete MPI Bulletins 76-91 and 76-142.

Changes on pages 242a and 242b delete MPI Bulletins 76-83 and 76-120.

NOTE

In the September Issuances, on the "Manual Maintenance Instruction" sheet, MPI Bulletin 872 was erroneously deleted. The correct MPI bulletin to be deleted by changes on page 279 is "842."



UNITED STATES DEPARTMENT OF AGRICULTURE
Animal and Plant Health Inspection Service
Meat and Poultry Inspection Program
Washington, D. C. 20250



MEAT AND POULTRY INSPECTION REGULATIONS

CHANGE: 76-10

October 1976

MAINTENANCE INSTRUCTIONS

Remove Page	Insert Page	Numbered
SUBCHAPTER A - MANDATORY MEAT INSPECTION		
vii	vii	76-10
viii	viii	76-10

85	85	76-10
86	86	76-10

103	103	76-10
104	104	76-10

123	123	76-10
124	124	76-10

141	141	76-10
142	142	76-10
	142a	76-10

PEN-AND-INK CHANGES:

On page 129 of the meat inspection regulations, second paragraph, 11th line, change the word "remainder" to "remainder."

On page 55 of the poultry inspection regulations, first line, change the word "post-mortem" to "post-mortem."

PART 16

MARKING
PRODUCTS AND CONTAINERS

MARKING DEVICES

Subpart 16-A

(Regs: M-312, 316)

16.1 APPROVAL

(a) Marking Device

Imprints of any marking device or other devices, submitted through the inspector in charge to STS-LP for approval, shall be legible and as required by regulations.

(b) Official Mark, Advertisement

Approval of official marks appearing in newspaper advertisements, billboards, etc., is unnecessary; however, such marks may be reviewed locally before publication; they should conform to standards and not be misleading.

(c) Stencil, Stamp, Pencil

Inspector in charge may approve stencils, rubber stamps, pencil marks or prints applied to shipping containers. They may be used in addition to required markings and must not be false or misleading. Official inspection mark must be approved by STS-LP.

(d) Grade Marking

The inspector in charge may approve Federal (sec. 16.8(a)(1)) or State grade markings applied to carcasses and cuts at federally inspected plants by, or under, the supervision of Federal or State grading employees. Other grade markings shall be approved by STS-LP.

(e) Roller Brand, Papain (Meat)

Roller brand imprints, used on carcasses injected with papain, shall be approved by STS-LP.

16.2 BRANDS (Meat)

(a) Size, Design

Official brands must be uniform in size and design, and must conform to specifications (MR-312).

(b) Approval, Use

Approval and use of official brands shall be according to regulations.

(1) **Sanitation.** Brands bearing inspection or other marks shall be kept clean while in use.

(2) **Misuse.** Inspection marks shall not be used on clothing, walls, posts, and the like.

(3) **Buyer's brands.** These brands and marks shall be so applied as not to obliterate or be confused with required markings.

(4) **Hot iron brand.** Legibility may be improved by drilling two small holes (1/16 inch diameter) through the hot iron brand's face to allow steam escape.

A cast steel burning brand improves the imprint on cured products.

(5) **Hot ink brand.** Ink brands, equipped with a thermostatic control, improve branding of meat, meat byproducts, and meat food products.

(6) "U.S. Insp'd and Condemned,"

"U.S. Passed for Cooking." These brands shall be used for marking carcasses and parts. They should not be substituted by other marks or tags.

(c) Supply, Replacement

Establishment supplies all brands, including replacements. Inspector in charge determines the number of brands to be replaced.

Exception! Brands for import inspection are supplied by MPI.

(d) Control

MPI employees must always control all official brands--in use or in storage. Plant owners and operators must make arrangements with the inspector in charge to carry this out.

(1) Delivery. New brands shall be immediately delivered into the inspector's custody.

(2) Record. A current inventory of all official brands--used or stored, lost or unserviceable--shall be maintained as prescribed by RD.

(3) Disposal. A legible imprint cannot be made with worn or unserviceable brands. Therefore, such brands shall be defaced and disposed of at the plant.

The aluminum handle of the 2 1/2 inch rubber brand, supplied by the Department, should be returned to the Washington office for reuse.

* 16.3 SEALS; CONTROL (Meat)

* Official seals received at regional
* offices shall be controlled under
* security. This includes logging in new
* shipments, inventoried storage, and
* logging out shipments to specific field
* locations. Each shipment to the field
* shall be accompanied with two copies of
* a regional receipt for the seals.

* Shipments of official seals received
* at field locations shall be checked for

accuracy. Inspectors will date and
sign accepted shipment receipts, also
noting "shipment received intact" and
return one signed copy to the regional
office. Questionable shipments
shall immediately be reported to the
circuit supervisor.

Official seals used for any reason
shall be recorded by serial numbers.
Recordings shall also indicate "date
affixed" and "where affixed," and
whenever applicable, "date broken."
Each recording will be signed by the
inspector who affixes or breaks a
seal.

Official seal inventories shall be
adjusted at least daily to reflect
any change in count of seals on hand.

MARKING (MEAT)

Subpart 16-B

(Regs: M-312; 316)

16.6 CARCASS BRANDING

(a) Each Half

Each half carcass shall be legibly
marked "U.S. Inspected and Passed"
after inspection has been completed.

(b) Shrouded Carcasses

Shrouding should not cause smeary
and illegible brands.

When shrouded carcasses are shipped
from an official plant, additional
brands--clearly visible without cloth
removal--shall be applied to carcasses
if necessary. When such carcasses
are placed in bags or other coverings,
the outer coverings shall bear prominent
and legible official inspection legends.

(c) Brand Number, Location

Designating the number and/or location of brand imprints to be applied on carcasses is impractical. However, local circumstances may require more than the minimum number on each half carcass.

(d) Cysticercosis (Beef)

Beef cysticercosis carcasses, passed for refrigeration (meat regulations 311.23), may be marked "U.S. Inspected and Passed" just before being placed into a freezing compartment under Government lock or seal.

(e) Papain Injected Carcasses

Carcasses of animals injected with papain shall be marked "Tendered with Papain" with continuous marks applied by a roller brand over the round, loin, rib, neck, chuck, foreshank, flank, plate, and brisket.

Chart 20.1 - Forms, con't.

Form	Use	Copies	Submittal	Distribution	Other Information
MP 441, Permit to Ship Meat or Poultry Labels Between Official Establishments	Transfer of labels between plants	See form	With each batch of labels	See form	
MP 448, Injury Register	Injury		See form	See form	
MP 449, Reporting Kit	Injury		See form	See form	
+MP 450, Scoresheet for Boneless Manufacturing Meats other than Pork	Boneless meat inspection	2	Upon completion	Gov. office-orig. and copy	Complete for domestic and import inspection--1,2,11,12,13,14,15,16, 17. Domestic only--3, 4,5,6,7. Import only--8,9,10. See also form and Subpart 18-B.
+MP 450-1, Online Inspection of Boneless Manufacturing Meats other than Pork	Boneless meat reinspection (online)	2	Completed and filed by plant	Available to MPI personnel	See also Subpart 18-B
+MP 450-2, Worksheet for Form MP 450 (Imported Meats)	Boneless imported meat	1	Upon completion	Gov. office	See form
MP 455, Sanitation Report	Daily sanitation	2	Weekly	See form Gov.office-orig. Plant-copy	Explain items marked "N" or "U" in "remarks". Upon report completion, inspector and plant official should sign.
+MP 460, Condition of Container (Scoresheet)	Import product	3	Upon completion	Gov.office-copy Plant - copy	Use tightened plan for reinspections See sec. 20.17
MP 462, Establishment Workload and Assignment Computation	Workload and assignment	3	Completed by Circuit Supervisor	Reg. office-orig. Area Sup.-Copy Gov. Office-Copy	
MP 480, Application for Approval of Label, Formulation, or Device	As required	3	By plant for each label	STS-LP Gov. office plant	See form
MP 486, Net Weight Report	Net weight	1	Upon completion	Gov. office	See form
MP 490, Assignment Record	Program planning, operating, and controlling. Maintaining current assignment data	4	Completed by Area Supervisor. Orig. and copies to RD	Reg. office-orig. STS-WSDS-Copy- Area office-copy Circ. Sup.-Copy	
MP 491, Assignment Report	Assignment	3	Completed by Area Supervisor	See form	

215a

Chart 20.1 - Forms, con't.

Form	Use	Copies	Submittal	Distribution	Other Information
* ++MP 505, Poultry Inspection Certificate	Upon request: 1. According to 381.108. 2. In lieu of MP 506.	4	Upon completion	Shipper - orig. & 1st copy; Area office-2nd copy. Gov. office-3rd copy	See Regulations 381.108 and Manual 22.14(a)
++MP 506, Export Certificate	Export	6	Upon completion	Shipper - orig. and 1st copy. Plant - 2nd copy. DSC, Des Moines, Iowa - 3rd copy. Gov. office-4th copy. Area Sup.-5th copy	See form
+MP 508, Notice of Shipment of Material derived from United States Inspected and Passed Carcasses, but not Eligible for the mark of Inspection for Use in Certified Animal Food	Certified animal food	4	Upon completion	See form	
++MP 513, Poultry Inspection Daily Summary	Summary of lot information	1	Weekly	DSC, Des Moines, Iowa	See form
++MP 514, Poultry Inspection Lot Tally Sheet	Each lot inspected	1	Upon completion of lot inspection	Gov. office	Retain in inspector's possession or in Gov. office at all times.
++MP 514-1, Poultry Condemnation Certificate	Each lot	4	Upon completion	Plant - orig. and 2 copies Gov. office-copy	See form
++MP 514-2, Poultry Lot Information	Each lot	1	After lot is packed	Gov. office	See form
* ++MP 519, Scoresheet for Carcass Meat and Meat Byproducts	Carcass reinspection; each lot	3	Weekly	DSC, Chicago - orig. Gov. office-duplicate. Plant-triplicate	See sec. 20.18
++MP 526, Application for Inspection Service on Poultry Products Frozen Away from Official Plant	Inspection of off-premise freezing	5	By applicant	See form	
++MP 528, Moisture Absorbed by Poultry	Chilling procedure change	2	By plant	Gov. office-orig. Plant - copy	See form

tary conditions and was inspected for wholesomeness by the United States Department of Agriculture at time of slaughter. This inspection was carried out under the supervision of Federal veterinarians and each carcass, including its organs, was passed and certified as being free from evidence of communicable disease and is otherwise wholesome, sound, healthy, clean, and fit for human food."

Official Veterinarian

22.25 COLOMBIA

Meat Products

Lard. Issue MP Form 412-7 in five copies. Fifth copy is for inspector's file.

Certificate should be visaed by consul of that country.

22.26 CZECHOSLOVAKIA

Meat Products

Lard. The following certification, on reverse of regular export certificate or on departmental letterhead stationery, may accompany lard:

1. Originates from hogs found to be healthy before, during, and after slaughter, and that the meat, including fat, is suitable for human consumption without any restrictions.

2. Antioxidants were not used in producing lard.

22.26-A DENMARK

* (a) Meat Products

* Fresh meat (beef) may be exported to
* Denmark if accompanied by the following
* certification, typed on USDA/APHIS let-
* terhead stationery, signed by an MPI
* veterinarian, and attached to the orig-
* inal of MP Form 412-3:

* I further certify that:

* 1. The meat described herein is
* derived from animals which were located
* in the United States during the 3-month
* period immediately before slaughter (or

since birth for animals less than 3 months old).

2. The animals were from areas not restricted for infectious livestock diseases.

3. The areas from which the animals originated have been free of rinderpest and foot-and-mouth disease of the exotic virus type for the last 12 months, and the animals have not been vaccinated against these diseases.

4. The animals from which the herein described meat was derived were slaughtered at official establishment(s) no. _____.

5. The meat was cut up at official establishment(s) no. _____, and was prepared and packed at a temperature not exceeding 10° C. (50° F.).

6. Neither the animals nor the meat were treated with chemical substances or in any other way that would represent a health hazard to the consumers.

7. Processing, packaging, and shipment of the meat has taken place in a hygienic fashion.

Plant management must identify to the MPI veterinarian the origin of cattle from which the meat will be derived for export to Denmark, to enable him to provide the certifications in items 1 and 2. Establishments receiving Canadian or Mexican cattle are not eligible to export to Denmark unless they have a positive system of identifying meat's origin through all stages of preparation-slaughter to final product.

Item 2 refers to tuberculosis and brucellosis. Inspectors in charge must contact the nearest VS office to be certain cattle to be slaughtered are not from areas quarantined for these diseases.

Item 6 does not refer to DES; inspected and passed meat from any official establishment will qualify under this item.

(b) Poultry Products

Cooked poultry products may be exported, provided:

a. They are packed in containers bearing official inspection mark.

b. Each shipment is accompanied by a health certificate signed by an MPI veterinarian stating:

1. The product described herein was produced under official inspection.

2. Only (species) meat was used in the product which was from birds examined under official inspection before and after slaughter and were found suitable for human food.

3. The product has been heated to an internal temperature of at least 75° C. (167° F.) and does not contain additives not permitted under Danish legislation.

4. Neither the birds nor the meat, in accordance with U.S. legislation, has been treated with chemical or biological substances, or in any other way which could represent a health hazard to consumers.

Item 4 can be routinely certified on the basis that all products must be safe for human health to meet U.S. standards.

The above certification statements are to be typed in the "remarks" block of MP Form 506. Available space above the "remarks" block may be used also.

Danish officials will accept poultry products cooked to an internal temperature of 160° F., as required by regulations (381.150). Research has proven that when cooked poultry is removed from the cooker at 160° F. its internal temperature continues to rise for several minutes and then drops very slowly to room temperature. Therefore, the above certification can be made on this basis.

The following additives, normally used in the United States, are permitted by Danish legislation in the amounts shown:

Butylated hydroxyanisole (BHA), butylated hydroxytoluene (BHT), propyl gallate----- 50 mg/Kg

Citric acid, monoisopropyl citrate, monoglyceride citrate----- 50 mg/Kg

Algin, carrageenan, carboxymethyl, cellulose (cellulose gum), vegetable gums, methyl cellulose----- 5 gm/Kg

Anatto, carotene-----200 mg/Kg

Nitrites, sodium or potassium nitrate----- 50 mg/Kg

Ascorbic acid, erythorbic acid, sodium ascorbate, sodium erythorbate-----500 mg/Kg

Acetylated monoglycerides, diacetyl tartaric acid esters of mono- and diglycerides, mono- and diglycerides (glycerol palmitate, etc.)--- 5 gm/Kg

Disodium inosinate, disodium guanylate----- 50 mg/Kg

Monosodium glutamate----- 3 gm/Kg

Phosphates listed in section 381.147 (f)(3) of the poultry inspection regulations----- 5 gm/Kg

22.27 DOMINICA

Poultry Products

Poultry and poultry products for Dominica must be accompanied by MP Form 506, signed by an authorized MPI officer, and with statement that poultry or carcasses were not treated with estrogens, arsenical, or antimonial substances. This applies to poultry and poultry products imported or delivered for reexport.

22.28 DOMINICAN REPUBLIC

(a) Meat Products

Export certificate to be visaed by consul of that country.

(b) Poultry Products

Official certification is required on MP Form 506 stating that product is Grade "B" or better, and has been under refrigeration for not more than 4 months.

22.29 EQUADOR

Meat Products

Certificate to be visaed by consul of that country.

22.30 FRANCE

(a) Meat Products

Use MP Form 412-11 and MP Form 81 for fresh meats and byproducts.

(1) **Livers (R).** Beef and sheep livers must be inspected as follows:

- a. Open bile duct by usual method.
- b. Make a transverse incision across omasal impression of liver's visceral surface, sufficiently deep to cut smaller branches of bile duct.
- c. Make a second transverse incision across liver's visceral surface from beside and below caudate lobe, cutting smaller branches of bile duct.

Note: This procedure is as required on beef and sheep livers for Germany (See Figure 22.2).

(2) **Unscalded Stomachs (22.17(b)(2)).**

- * (3) **Branding.** Organs such as livers,
- * tongues, hearts, etc., from swine,
- * sheep, or goats need not be branded.

(4) **Pork meats.** For pork or products with pork, the following statement must appear on MP Form 412-11:

"This product is derived from animals originating outside any zone restricted because of hog cholera and/or swine vesicular disease.

Ces produits de porc ou d'abats de porc ne sont pas de provenance d'animaux élevés dans une zone en quarantaine pour peste porcine ou maladie vésiculeuse de porc."

The French definition of restricted zone is that farm, county, state(s) placed under official quarantine or other restriction due to an animal disease.

Pork and pork cuts may be certified for export if frozen for destruction of trichinae as follows:

- 30 days at -15° C. (+5° F.)
- 20 days at -23° C. (-9.4° F.)
- 12 days at -28° C. (-18.4° F.)

(5) **Bulk product; storage.** Bulk product may be stored, trichinae treated, and packed in a cold storage operating under Identification Service. In such case, labels (interior and exterior) will bear an inspection legend with an establishment number in the 3000 series. MP Form 412-11 must

show name, address, and establishment number of producing plant; and name, address, and establishment number of the cold storage.

(6) **Cuts, packages.** Boneless or bone-in cuts weighing more than 6 1/2 pounds must be branded. When small cuts of less than 6 1/2 pounds are wrapped or packaged, wrapping or package should show: (1) name, location, and license number (inspection legend) of preparing plant; (2) species and name of cut; (3) net weight; and (4) packaging date.

Individual packages or cuts shall be in containers showing above labeling features.

(7) **Duplicate labels.** Packages of meat, meat food product, or edible byproducts must be identified with serially numbered duplicate labels. One label shall be applied to outside of container and one to the interior of the package.

The label must show:

1. Serial number.
2. Description of product, including species from which derived.
3. Net weight.
4. Inspection legend (MR-312.2).
Item II of MP 412-11, "Address of the Approved Slaughterhouse or Houses," should show the plant where product was last handled or packed.
5. Freezing date (See 22.30(a)(10)).

(8) **Processed product.** Use MP Form 412-12 to certify processed meats, including edible fats. Official inspection seal should be placed on lower left part of the certificate. Duplicate labels are not required for packaged and labeled product certified with this form.

Retail packages. All canned or frozen meat or meat food products in containers, to be sold at retail or institutional levels, shall be marked with date or code date of packing. Date marking of packages or cans may be in figures or in code. If shown in

code, such code must be given to French Ministry of Agriculture by exporter or his agent. Code information should be directed to: Service de La Reprission des Fraudes, Ministere de l'Agriculture, Paris, France.

Frozen product, meat or edible byproduct imported in large packages (bulk), is not covered by this rule.

(9) Casings. MP Form 412-12 shall be used with MPI seal impression.

Casings may be certified from unofficial premises, provided:

1. Plant preparing casings is open at all times to Federal inspectors.

2. Inspections are made periodically to insure that proper hygienic standards are maintained.

3. Casings are from animals slaughtered under Federal inspection.

4. Inspected plants from which casings are obtained are recorded under Item 11 "Origin of the foods."

(10) Freezing. Meats must be frozen and stored at -10° C. ($+14^{\circ}$ F.) or below and byproducts at -12° C. ($+10.4^{\circ}$ F.) or below. Freezing dates must be (i) stamped on both labels (22.30(a)(7) and 22.30(b)(2)) of each carton, (ii) followed by "C" if the product has been frozen once and by "T" if it has been thawed and refrozen, and (iii) shown on MP Form 81. If the freezing dates of a lot vary, enter on the MP 81 the first and last dates. The month may be spelled out or abbreviated, but it must not be shown numerically.

* (11) Edible product for animal food.
 * Such product must meet all the requirements of edible product except those
 * for carton marking and certification.
 * Cartons must bear all required features
 * including inspection legend and be
 * marked "For Animal Food - For Export to
 * France." Issue MP Form 412-3 for meat/
 * byproducts and MP Form 414-3 for horse-
 * meat/byproducts, with the additional
 * certification typed on the reverse or
 * on separate USDA-APHIS letterhead:

a. Product was produced from animals that originated in areas free from foot-and-mouth disease for at least 30 days prior to slaughter and was kept away from contaminated animals during transport and while in the slaughterhouse.

b. Product was produced from animals slaughtered in establishments subject to constant veterinary inspection and acknowledged free from contagious diseases.

c. Product has been trimmed of damaged or spoiled parts.

d. Product was prepared and dispatched following every normal rule of hygiene.

Certificates must also be marked "For Animal Food" and be signed by an MPI veterinarian.

Other French requirements will not apply to this product.

(12) Pharmaceutical products. Issue MP Form 17.

(b) Poultry Products

Livers. Shipment of poultry, except livers, from countries not prohibiting by law use of arsenicals, antimonials, or estrogens in production of poultry is prohibited. Only livers can be shipped to France from USA.

(1) Labeling. Shipping containers must bear all mandatory labeling information. An additional label with inspection legend and plant number must be placed on top of product inside shipping container. Freezing dates must be shown on inside and outside labels. All individual containers placed within a shipping container shall be fully labeled on the outside.

(2) Freezing. Product must be frozen and stored at -12° C. ($+10.4^{\circ}$ F.) or below. Other freezing requirements are the same as for meat (See 22.30(a)(10)).

(3) Certification. Issue MP Form 506, MP Form 81, and MP Form 82. These forms must be signed by an MPI Veterinarian. The name of the ship by which the product is transported should be shown on MP Form 82 and on MP Form 506 (under "remarks").

cholera, and (2) are free of hog cholera quarantine restrictions when shipped for slaughter.

(b) Poultry Products

On an individual request basis, veterinary inspectors may state on export certificates covering shipments passing through East Germany

22.31 GERMANY (EAST GERMANY)

(a) Meat Byproducts

Use MP Form 412-3. Upon plant's request, the MPI veterinarian signing the certificate may certify and sign on its reverse side the following required information:

1. Byproducts were produced in plants under constant veterinary supervision.

2. Animals, from which byproducts were obtained, originate from stock free of acute animal epidemics--hog pest, hoof-and-mouth disease, etc.--during the last 3 months.

3. Animals from which byproducts were obtained were examined by a veterinarian, before and after slaughter, and were found healthy.

4. Territories through which swine were transported to port of loading, and port of loading itself, were not subject to any traffic restrictions for swine pest and hoof-and-mouth disease.

5. Byproducts are fit for human consumption without any restrictions, and do not contain any preservatives.

6. Wrapping material used is acceptable from a veterinary hygienic viewpoint.

7. Means of transportation have been disinfected with procedure recognized by legal authority. Means of transportation and condition of loading correspond to minimum requirements.

Hog cholera restriction. Hog pest is the European term for hog cholera. Pork byproducts must be obtained from hogs that (1) originate in States with a quarantine program for hog

The establishment number will be that of the plant making the shipment. Letters and figures in the stamp must be at least 2 millimeters high. This mark will be considered part of the label and should be printed on labels submitted to STS-LP for approval. Plain bags or cartons may not be used.

Under U.S. inspection regulations, all consumer packaged poultry--halves, breasts, legs, thighs, and drumsticks bearing letter grade designations (A, B, or C)--must be officially graded by licensed grader of the Grading Branch, Poultry Division, AMS.

Exception! Regulations do not apply to rock cornish game hens, guineas, boneless rolls, and certain parts--wings, backs, necks, tails, and giblets.

Product labeled "deep frozen" must meet extremely restrictive requirements. It may be desirable to avoid this term and use "frozen."

Labels with German language may be applied by using stickers which cannot be removed, or by inserts placed between product and wrap. However, labeling shall be clearly visible and of approximately same size, type, and boldness of U.S. printing.

Labels shall be sent to STS-LP for approval.

(5) Backs. When poultry or poultry products for export to Germany include ready-to-cook poultry "backs," "stripped backs," "backs and necks," or any combination, the inspector (or grader) shall add the following German wording on the certificate after name or kind of product (appropriate space): "Huehnerschlachtabfall, Geniessbar." This term means "byproduct" and is desired by German officials. It does not apply to any other product and should not be used for whole carcasses; i.e., fryers, young turkeys, etc.

22.33 GREAT BRITAIN - UNITED KINGDOM

(a) Meat Products

Meat and meat food products, except those for U.S. military forces, must originate in MPI certified plants.

(1) Plant approval. Plants, including horsemeat plants, desiring to export to the United Kingdom (UK) must meet the requirements of this section and submit an application (MP Form 67) through RD to the Deputy Administrator.

(i) Facilities and equipment. Rooms or areas where stomachs or intestines are emptied should be adequately separated from slaughtering and dressing operations and from any area where meat or byproducts are handled or stored. This may be accomplished by physical means, such as shields, walls or distance.

Wooden pallets may not be used near or for exposed product.

(ii) Water supply. In canneries, a bacteriological examination of the water supply must be done monthly; in other plants, more frequently than once yearly for municipal water and more frequently than twice yearly for well water.

(iii) Clothing. Employees handling edible product or working in edible product areas must wear suitable protective clothing, including head covering and footwear (with rubber or plastic soles), capable of being cleaned and kept clean. Street clothing is not permitted.

(iv) Canning. Seams of can ends should be routinely checked. Hydrostatic retorts must be cleaned as necessary and replacement water must be added to cooling water reservoirs to prevent buildup of organic material. Can cooling water should be checked periodically and kept clean. The level of available chlorine in this water

* should not fall below .5 ppm and should be checked frequently. After retorting, cans should be cooled and thoroughly dry before manually handled. All can handling equipment must be easily cleaned.

(2) Eligible product; certification. It is the responsibility of the importer to assure that products meet the compositional standards expressed in the British "Sausage or Other Regulations 1967."

All certificates and supplementary statements must be signed by an MPI veterinarian. A copy of the certificates, MP Form 412-3 or MP Form 414-3, must be attached to and remain with the original certificates. Certain federally inspected plants are approved by VS for immediate slaughter of cattle, sheep, and swine from Canada, and for cattle and sheep from Mexico. Meat and byproducts produced in such plants should not be certified for export to UK unless arrangements, satisfactory to the veterinarian in charge, are made to identify and segregate the articles from product intended for export to UK. The following products may be exported:

(i) Fresh. Meat and byproducts from cattle, calves, sheep, and equines. For meat and byproducts from cattle, calves, and sheep, issue MP Form 412-3, MP Form 412-10, and MP Form 93. The animal disease situation in the United States is such that the required statement on MP Form 93 can be routinely made.

For meat and byproducts from equines (horse, ass, mule), issue MP Form 414-3 and MP Form 414-4. The following typewritten statement should be added on the reverse of MP Form 414-3: "This consignment does not contain a mixture of any meat, byproducts, or any other product derived from any ruminant or swine, nor any other product derived from horse, ass, or mule."

(ii) Fresh pork for military forces. Fresh meat/byproducts from swine may be shipped only to U.S. military forces.

Issue MP Form 412-3 with the following statements:

"The pigs, from which the meat, products, or byproducts were obtained, were derived from U.S. premises which (a) have been free from swine fever for the preceding 12 months, and (b) were not within 20 miles of any premises where an outbreak of swine fever has been recorded in the preceding 12 months."

"The refrigerated pork meat and byproducts, and the processed pork products are from federally inspected slaughterhouses and processed products (such as sausages) are from plants which obtain meat exclusively from federally inspected plants."

(iii) Cured. Cured hams/bacon may be exported.

Issue MP Form 412-3 with a statement typed thereon describing the curing process used, which shall be one of the following:

1. Pumping with brine under a pressure of 80 pounds or more to the square inch and subsequently soaking in brine or dry salting for at least 4 days.

2. Salting (wet or dry) for at least 10 days.

3. Pumping with brine under a pressure of 50 pounds (PSI) with subsequent smoking for at least 12 hours at a temperature not less than 120° F. for bacon.

(iv) Cooked. Meat/byproducts from all species must be fully cooked. UK considers meat fully cooked if pink juices cannot be expressed. Cooked beef fat tissue solids (CBFTS) and their raw materials must be from MPI certified plants. Issue MP Form 412-3 and MP Form 412-10. Add the following typewritten statement on the reverse of MP 412-3: "I certify that the meat described in the schedule below has been prepared under the terms and

conditions of an official certificate recognized by the Minister of Agriculture, Fisheries and Food, and the Secretary of State for Scotland in accordance with the provisions of the Imported Food Regulations 1968 (or the Imported Food (Scotland) Regulations 1968)."

(v) Canned. Shelf-stable canned product from all species, packed in hermetically sealed metal or glass containers, may also be exported. Issue MP Form 412-3 and MP Form 412-10.

(vi) Product for U.S. military forces. Certification requirements for product other than fresh pork (see 22.33(a)(2)(ii)) are the same as for commercial shipments, except that MP Form 412-10 is not issued.

(vii) "Papain" Kidneys. When they are to be shipped for edible purposes they must be (1) from federally inspected carcasses, (2) handled as edible product, (3) kept identified, and (4) packed in containers labeled "Beef Kidneys - Tendered with Papain - For Export Only."

(viii) Casings. They must be:

a. Accompanied by a declaration on USDA letterhead stationery signed by an authorized veterinary officer stating that casings were cleaned and scraped.

b. Identified by approved label with inspection legend including an establishment number in the 3,000 series (Food Inspection Service). To be eligible for inspection mark, casings must be sanitarily handled and from official plants, or must be packed under Food Inspection Service.

c. Upon exporter's request, accompanied by MP Form 415-5.

(ix) Fats, oils.

1. Certification. Issue MP Form 412-3 and MP Form 412-10. Include the following on the export certificate:

a. Location of tanks. For example, Port #3 or Starboard #2 shall be shown in the space for "Shipping Marks" and "Stamp Numbers." Tanks shall be identified again in the "No. Column" as P-3 or S-2.

b. For each tank, the estimated product weight shall be listed in the weight column. Such weight may be obtained from marine surveyor.

c. A statement of cleanliness should be made in the description column to read: "Tanks were inspected and found to be clean."

2. Requirements:

a. Ship tanks. They will be inspected and passed for cleanliness before product is loaded onto the ship. Marine surveyors will do this inspection under general inspector's supervision. To be acceptable, tanks must be clean, dry, and free of residues from previous cargoes.

b. Product from I.D. Service. When product is shipped from an Identification (ID) Service place, an inventory of federally inspected lard or rendered fats will be maintained. Records will include additions to and removals from each storage tank. Inspector should be able to estimate product amount in storage at any time. An inspection opening is required on each tank. Tank connection to any line will be broken by removal of a 1-foot section of pipe when tank is sealed. Transfer from tank to ship is permitted only through a line without other connections than to the tank. Product transfer may also be accomplished by use of tank trucks. Ship tanks shall be examined to assure they are empty before operations start. Loading will be done under continuous supervision of the inspector. If operations are interrupted for any reason, the hatch on the tank must be sealed. The seal must not be broken until operations are resumed.

c. Label. Approved label(s) bearing printed inspection legend with establishment number (317.2) will be

attached to the export certificate. Establishment number will be in the 3,000 series for product shipped from an ID Service installation. One export stamp will be issued for each ship's tank. Stamps shall be attached to all hatches of filled tanks. Original export certificate and attached label(s) shall be delivered to the shipper, who shall deliver them to the chief officer of the vessel carrying the shipment. The chief officer shall present the certificate and label(s) to the port health authority on arrival in UK.

d. Antioxidants. Edible fats and oils may contain antioxidants in the following amounts:

Propyl gallate, octylgallate, dodecylgallate, or any mixture of the three-----100 ppm
Butylated hydroxyanisole (BHA)-200 ppm
Butylated hydroxytoluene (BHT)-200 ppm
Any mixture of BHA and BHT-----200 ppm
Citric Acid-----100 ppm

When product contains antioxidants, the label must include a description of antioxidants, and maximum amount expressed in parts per million.

(3) Marking, labeling. UK recognizes the Federal meat inspection legend, with establishment number of producing plant, as being the "official certificate" for importation of product from the United States. Such legend must be as required by regulations (312.2), and must be affixed to all shipping cartons. For large containerized shipments (vans), it must be attached to the container. If the container holds product from more than one plant, it must bear an inspection legend from each official plant represented by the product inside. Legend or product label with inspection legend may be applied to containers at places outside official plants by using ID Service (R).

To comply with regulations (322.4), issue MP Form 412-3 and MP Form 412-10.

(4) Prohibited importation. The following importations are prohibited:

a. Fresh pork/byproducts (except to U.S. military forces; 22.33(a)(2)(ii)).

b. Scrap meat. Meat consisting of scraps, trimmings, or other pieces (with or without bone) of such shape or in such condition as to afford insufficient means of identification with a definite part of a carcass.

c. Any carcass part chopped or minced with or without spices, cereal products, salt, flavoring, vegetables, or other ingredients.

Exception: Beef patties, flake steaks, fresh beef or pork sausage, etc., may be shipped to the military.

d. Heads without submaxillary lymph nodes.

e. Livers without hepatic lymph nodes. These nodes must be incised (R) and left attached to the livers. Livers not meeting this requirement will be rejected.

f. Boneless meat from calves less than 3 months old.

(5) Ports of Entry. Fresh, chilled, or frozen meats or byproducts may enter UK only through the following ports: Avonmouth, Cardiff, Dover (Eastern Docks), Felixstowe, Folkestone, Great Yarmouth, Grimsby, Harwich, Liverpool, London (Royal Group), London (Tilbury), Newhaven, Plymouth, Sheerness, Southampton, and Tyne (North Shields).

Processed or canned products are permitted entry at all ports.

(b) Poultry Products

(1) Plant approval. Federally inspected plants desiring to export fresh poultry products to UK must apply to RD. MP Form 46 shall be used. In certifying such plants, RD will apply the same criteria used in certifying poultry plants for slaughter/cutup to West Germany. Plants certified for West Germany are considered certified also for UK and need not apply for additional certification.

- 317.10 Reuse of official inspection marks; reuse of containers bearing official marks, labels, etc.
- 317.11 Labeling, filling of containers, handling of labeled products to be only in compliance with regulations.
- 317.12 Relabeling products; requirements.
- 317.13 Storage and distribution of labels and containers bearing official marks.
- 317.14 Reporting of obsolete labels.
- 317.15 [Reserved]
- 317.16 Labeling and containers of custom prepared products.
- 317.17 Interpretation and statement of labeling policy for cured products.
- 317.18 [Reserved]
- 317.19 Jar closures requirements.

PART 318-ENTRY INTO OFFICIAL ESTABLISHMENTS: REINSPECTION AND PREPARATION OF PRODUCTS

Sec.

- 318.1 Products and other articles entering official establishments.
- 318.2 Reinspection, retention, and disposal of meat and poultry products at official establishments.
- 318.3 Designation of places of receipt of products and other articles for reinspection.
- 318.4 Preparation of products to be officially supervised; responsibilities of official establishments.
- 318.5 Requirements concerning procedures.
- 318.6 Requirements concerning ingredients and other articles used in preparation of products.
- 318.7 Approval of substances for use in the preparation of products.
- 318.8 Preservatives and other substances permitted in product for export only; handling; such product not to be used for domestic food purposes.
- 318.9 Samples of products, water, dyes, chemicals, etc., to be taken for examination.
- 318.10 Prescribed treatment of pork and products containing pork to destroy trichinae.
- 318.11 Canning with heat processing and hermetically sealed containers; cleaning containers; closure; code marking; heat processing; incubation.
- 318.12 Manufacture of dog food or similar uninspected article at official establishments.
- 318.13 Mixtures containing product but not amenable to the Act.
- 319.14 Adulteration of product by polluted water, etc.; procedure for handling.
- 318.15 Tagging chemicals, preservatives, cereals, spices, etc., "U.S. retained."
- 318.16 Pesticide chemicals and other residues in products.

PART 319-DEFINITIONS AND STANDARDS OF IDENTITY OR COMPOSITION

Subpart A--General

Sec.

- 319.1 Labeling and preparation of standardized products.
- 319.3 Mechanically deboned and low temperature rendered meats.

Subpart B--Raw Meat Products

- 319.15 Miscellaneous beef products.
- 319.29 Miscellaneous pork products.

Subpart C--Cooked Meats

- 319.80 Barbecued meats.
- 319.81 Roast beef parboiled and steam roasted.

Subpart D--Cured Meats, Unsmoked and Smoked

- 319.100 Corned beef.
- 319.101 Corned beef brisket.
- 319.102 Corned beef round and other corned beef cuts.
- 319.103 Cured beef tongue.
- 319.104 Cured pork products, unsmoked or smoked.
- 319.105 Chopped ham.

Subpart E--Sausage Generally: Fresh Sausage

- 319.140 Sausage.
- 319.141 Fresh pork sausage.
- 319.142 Fresh beef sausage.
- 319.143 Breakfast sausage.
- 319.144 Whole hog sausage.
- * 319.145 Italian sausage products.

Subpart F--Uncooked, Smoked Sausage

- 319.160 Smoked pork sausage.

Subpart G--Cooked Sausage

- 319.180 Frankfurter, wiener, vienna, bologna, garlic bologna, knockwurst, and similar products.
- 319.181 Cheesefurters and similar products.
- 319.200 Liver sausage and similar products.

Subpart H--[Reserved]

Subpart I--Semi-Dry Fermented Sausage [Reserved]

Subpart J--Dry Fermented Sausage [Reserved]

Subpart K--Luncheon Meat, Loaves and Jellied Products

- 319.260 Luncheon meat.
- 319.261 Meat loaf.

coverings of product shall be submitted for approval in the same manner as provided for labels in paragraph (a) of this section, except that inspector in charge may permit use of such devices which contain no reference to product and bear no misleading feature.

(d) Stencils, labels, box dies, and brands may be used on shipping containers and on such immediate containers as tierces, barrels, drums, boxes, crates, and large-size fiberboard containers provided the markings are applicable to the product, are not false or deceptive, and are used with the approval of the inspector in charge. The inspection legend for use in combination with such markings shall be approved by the Administrator.

§ 317.5 Inspector in charge may permit modifications of approved labels.

The inspector in charge may permit modification of approved labels, or markings, under the following circumstances, provided the labeling or marking as modified is so used as not to be false or misleading:

(a) When all features of the label or marking are proportionately enlarged and the color scheme remains the same;

(b) When there is substitution of such abbreviations as "lb." for "pound," or "oz." for "ounce," or the word "pound" or "ounce" is substituted for the abbreviation;

(c) When a master or stock label has been approved from which the name and address of the distributor are omitted and such name and address are applied before being used (in such case, the words "prepared for" or similar statement must be shown together with the blank space reserved for the insertion of the name and address when such labels are offered for approval);

(d) When, during Christmas and other holiday seasons, wrappers or other covers bearing floral or foliage designs or illustrations of rabbits, chicks, fireworks, or other emblematic holiday designs are used with approved labels or markings. (The use of such designs will not make necessary the application of labeling not otherwise required);

(e) When there is a slight change in arrangement of directions pertaining to the opening of cans or the serving of the product;

(f) When there is a change in the quantity of an ingredient shown in the formula without a change in the order of predominance shown on the label: Provided, That the change in quantity of ingredients complies with any minimum or maximum limits for the use of such ingredients prescribed in Parts 318 and 319 of this subchapter.

§ 317.6 Approved labels to be used only on products to which they are applicable.

Labels shall be used only on products for which they are approved, and only if they have been approved for such products in accordance with § 317.3: Provided, That existing stocks of labels approved prior to the effective date of this section and the quantity of which has been identified to the circuit supervisor as being in storage on said date at the official establishment or other identified warehouse for the account of the operator of the official establishment may be used until such stocks are exhausted, but not later than 1 year after the effective date of this section unless such labels conform to all the requirements of this part and Part 319 of this subchapter. The

Administrator may upon the show of good cause grant individual extension of time as he deems necessary.

§ 317.7 Products for foreign commerce; printing labels in foreign language permissible; other deviations.

Labels to be affixed to packages of products for foreign commerce may be printed in a foreign language and may show the statement of the quantity of contents in accordance with the usage of the country to which exported and other deviations from the form of labeling required under this part may be approved for such product by the Administrator in specific cases: Provided,

(a) That the proposed labeling accords to the specifications of the foreign purchaser.

(b) That it is not in conflict with the laws of the country to which the product is intended for export, and

(c) That the outside container is labeled to show that it is intended for export; but if such product is sold or offered for sale in domestic commerce, all the requirements of this subchapter apply. The inspection legend and the establishment number shall in all cases appear in English but in addition, may appear literally translated in a foreign language.

§ 317.8 False or misleading labeling or practices generally; specific prohibitions and requirements for labels and containers.

(a) No product or any of its wrappers, packaging, or other containers shall bear any false or misleading marking, label, or other labeling and no statement, word, picture, design, or device which conveys any false impression or gives any false indication of origin or quality or is otherwise false or misleading shall appear in any marking or other labeling. No product shall be wholly or partly enclosed in any wrapper, packaging, or other container that is so made, formed, or filled as to be misleading.

(b) The labels and containers of product shall comply with the following provisions, as applicable:

(1) Terms having geographical significance with reference to a locality other than that in which the product is prepared may appear on the label only when qualified by the word "style," "type," or "brand," as the case may be, in the same size and style of lettering as in the geographical term, and accompanied with a prominent qualifying statement identifying the country, State, Territory, or locality in which the product is prepared, using terms appropriate to effect the qualification. When the word "style" or "type" is used, there must be a recognized style or type of product identified with and peculiar to the area represented by the geographical term and the product must possess the characteristics of such style or type, and the word "brand" shall not be used in such a way as to be false or misleading: Provided, That a geographical term which has come into general usage as a trade name and which has been approved by the Administrator as being a generic term may be used without the qualifications provided for in this paragraph. The terms "frankfurter," "vienna," "bologna," "lebanon bologna," "braunschweiger," "thuringer," "genoa," * "leona," "berliner," "holstein," "gotegorg," "milan," "polish," "Italian" and * their modifications, as applied to sausages, the terms "brunswick"

Class of substance	Substance	Purpose	Products	Amount	
* *			and serve sausage, Italian sau- sage products, pregrilled beef patties, and fresh sausage made from beef or beef and pork.]0.02 per- cent] combination] based] on fat] content]]]]	* *
	BHT (butylated hydroxytoluene).	do	do	do]
	Propyl gallate.	do	do	do]
	BHA (butylated hydroxyanisole).	do	Dried meats.	0.01 percent based on total weight.)))0.01 percent in)combination.
	BHT (butylated hydroxytoluene).	do	do	do))
	Propyl gallate.	do	do	do)
Binders.	Algin.	To extend and stabilize product.	Breading mix; sauces.	Sufficient for purpose.	
	Carrageenan.	do	do	do	
	Carboxymethyl cellulose (cellulose gum).	do	Baked pies.	do	
	Gums, vegetable.	do	Egg roll.	do	

Class of substance	Substance	Purpose	Products	Amount
	Methyl cellulose.	To extend and to stabilize product (also carrier).	Meat and vegetable patties.	0.15 percent
	Isolated soy protein.	To bind and extend product.	Sausage, as provided for in Part 319 of this subchapter.	2 percent.
			Imitation sausage; nonspecific loaves; soups; stews.	Sufficient for purpose.
	Sodium caseinate.	do	do	do
	Whey (dried).	do	do	do
	Xanthan gum.	To maintain: Uniform viscosity; suspension of particulate matter; emulsion stability; freeze-thaw stability.	Meat sauces, gravies or sauces and meats, canned or frozen and/or refrigerated meat salads, canned or frozen meat stews, canned chili or chili with beans, pizza topping mixes and batter or breading mixes.	Sufficient for purpose.

Dried meats. 0.01 percent on basis of total weight in combination with antioxidants.

Malic acid.	do	Lard and shortening.	do
Monoisopropyl citrate.	To increase effectiveness of antioxidants.	Lard, shortening, oleomargarine, fresh pork sausage, dried meats.	0.02 percent.
Phosphoric acid.	do	Lard and shortening.	0.01 percent.
Monoglyceride citrate.	do	Lard, shortening, fresh pork sausage, dried meats.	0.02 percent.

¹ These are proprietary products, and a list thereof can be obtained from Scientific Services, Meat and Poultry Inspection, Animal and Plant Health Inspection Service, U.S. Department of Agriculture, Washington, D.C. 20250.

² Information as to the specific products for which use of this substance is approved may be obtained upon inquiry addressed to Scientific Services, Meat and Poultry Inspection, Animal and Plant Health Inspection Service, U.S. Department of Agriculture, Washington, D.C. 20250.

(d) No substance may be used in or on any product if it conceals damage or inferiority or makes the product appear to be better or of greater value than it is. Therefore:

(1) Paprika or oleoresin paprika may not be used in or on fresh meat, such as steaks, or comminuted fresh meat food products, such as chopped and formed steaks or patties; or in any other meat food products consisting of * fresh meat (with or without seasoning), except chorizo sausage and except other * meat food products in which paprika or oleoresin paprika is permitted as an ingredient in a standard of identity or composition in Part 319 of this subchapter.

(2) Sorbic acid, calcium sorbate, sodium sorbate, and other salts of sorbic acid may not be used in cooked sausage or any other product; sulfurous acid and salts of sulfurous acid may not be used in or on any product and niacin or nicotinamide may not be used in or on fresh product; except that potassium sorbate, propylparaben (propyl p-hydroxybenzoate), calcium propionate, sodium propionate, benzoic acid, and sodium benzoate may be used in or on any product only as provided in the chart in § 318.7(c)(4) or as approved by the Administrator in specific cases.

§ 318.8 Preservatives and other substances permitted in product for export only; handling; such product not to be used for domestic food purposes.

(a) Preservatives and other substances not permitted in domestic product under the regulations in this subchapter may be used in the preparation and packing of product intended for export provided the product (1) accords to the specifications or directions of the foreign purchaser; (2) is not in conflict with the laws of the country to which it is intended for export; and (3) is labeled on the outside container to show that it is intended for export, and is otherwise labeled as required by this subchapter for such export product.

(b) The preparation and packing of export product as provided for in paragraph (a) of this section shall be done in a manner acceptable to the inspector in charge so that the identity of the export product is maintained conclusively and the preparation of domestic product is adequately protected. The preservatives and other substances not permitted in domestic product shall be stored in a room or compartment separate from areas used to store other supplies and shall be held under Program lock. Use of the preservatives or other substances shall be under the direct supervision of a Program employee.

(c) The packing of all articles under paragraph (a) of this section shall be conducted under the direct supervision of a Program employee.

(d) No article prepared or packed for export under paragraph (a) of this section shall be sold or offered for sale for domestic use or consumption, but unless exported shall be destroyed for food purposes under the direct supervision of a Program employee.

(e) The contents of the container of any article prepared or packed for export under paragraph (a) of this section shall not be removed, in whole or in part, from such container prior to exportation, except under the supervision of a Program employee. If such contents are removed prior to exportation, then the article shall be either repacked, in accordance with the provisions of paragraphs (b) and (c) of this section, or destroyed for food purposes under the direct supervision of a Program employee.

(f) Permission must be obtained from the Administrator before meats packed in borax are shipped from one official establishment to another or to

Certain sausage as provided for elsewhere in this part may contain binders and extenders; e.g., cereal, vegetable starch, starchy vegetable flour, soy flour, soy protein concentrate, isolated soy protein, nonfat dry milk, calcium reduced skim milk or dried milk. The finished product shall contain no more than 3.5 percent of these additives individually or collectively. Two percent of isolated soy protein shall be deemed equivalent to 3 1/2 percent of any one or more of these binders. Sausage may not contain phosphates except that uncooked pork from cuts cured with phosphates listed in § 318.7(c)(4) of this subchapter may be used in cooked sausage. To facilitate chopping or mixing or to dissolve the usual curing ingredients, water or ice may be used in the preparation of sausage which is not cooked in an amount not to exceed 3 percent of the total ingredients in the formula. Cooked sausages such as Polish sausage, cotto salami, braunschweiger, liver sausage, and similar cooked sausage products may contain no more than 10 percent of added water in the finished product.

§ 319.141 Fresh pork sausage.

"Fresh Pork Sausage" is sausage prepared with fresh pork or frozen pork, or both, not including pork byproducts, and may be seasoned with condimental substances as permitted under Part 318 of this subchapter. It shall not be made with any lot of product which, in the aggregate, contains more than 50 percent trimmable fat, that is, fat which can be removed by thorough, practicable trimming and sorting. To facilitate chopping or mixing, water or ice may be used in an amount not to exceed 3 percent of the total ingredients used.

§ 319.142 Fresh beef sausage.

"Fresh beef sausage" is sausage prepared with fresh beef or frozen beef, or both, not including beef byproducts, and may be seasoned with condimental substances as permitted under Part 318 of this subchapter. The finished product shall not contain more than 30 percent fat. To facilitate chopping or mixing, water or ice may be used in an amount not to exceed 3 percent of the total ingredients used.

§ 319.143 Breakfast sausage.

"Breakfast Sausage" is sausage prepared with fresh and/or frozen meat, or meat and meat byproducts and may be seasoned with condimental substances as permitted in Part 318 of this subchapter. It shall not be made with any lot of products which, in the aggregate, contains more than 50 percent trimmable fat; that is, fat which can be removed by thorough practicable trimming and sorting. To facilitate chopping or mixing, water or ice may be used in an amount not to exceed 3 percent of the total ingredients used. Extenders or binders as listed in Part 318 of this subchapter may be used to the extent of 3 1/2 percent of the finished sausage as permitted in § 319.140.

§ 319.144 Whole hog sausage.

"Whole Hog Sausage" is sausage prepared with fresh and/or frozen meat from swine in such proportions as are normal to a single animal and may be seasoned with condimental substances as permitted in Part 318 of this subchapter.

It shall not be made with any lot of product which, in the aggregate, contains more than 50 percent trimmable fat; that is, fat which can be removed by thorough practicable trimming and sorting. To facilitate chopping or mixing, water or ice may be used in an amount not to exceed 3 percent of the total ingredients used.

* § 319.145 Italian sausage products. *

* (a) Italian sausage products are uncured, unsmoked sausages containing *
* at least 85 percent meat, or combination of meat and fat, with the total fat *
* content constituting not more than 35 percent of the finished product. Such *
* products shall be prepared in accordance with the provisions of paragraphs (a) *
* (1), (2) or (3) of this section, and shall contain salt, pepper, and either *
* fennel or anise, or a combination of fennel and anise. Such products may con- *
* tain any or all of the optional ingredients listed in paragraph (b) of this *
* section. *

* (1) "Italian Sausage" shall be prepared with fresh or frozen pork, or *
* pork and pork fat. *

* (2) "Italian Sausage with Beef," "Italian Sausage with Veal," or "Italian *
* Sausage with Beef and Veal" shall be prepared so that fresh or frozen pork con- *
* stitutes the major portion of the meat content requirement of this paragraph. *
* When pork muscle tissue is combined with beef or veal, or both, in the prepar- *
* ation of bulk-packed products, or patties, it shall be treated for the *
* destruction of possible live trichinae in accordance with § 318.10 of this *
* subchapter. *

* (3) "Italian Beef Sausage" or "Kosher Italian Beef Sausage" shall be *
* prepared with fresh or frozen beef or beef and beef fat. "Italian Veal Sausage" *
* or "Kosher Italian Veal Sausage" shall be prepared with fresh or frozen veal *
* or veal and veal fat. *

* (b) Optional ingredients permitted in Italian sausage products include: *

* (1) Spices (including paprika) and flavorings. *

* (2) Water or ice to facilitate chopping or mixing, but not to exceed *
* 3 percent of the total weight of all ingredients including the water. *

* (3) Red or green peppers, or both. *

* (4) Dehydrated or fresh onions, garlic, and parsley. *

* (5) Sugar, dextrose, corn syrup, corn syrup solids, and glucose syrup. *

* (6) Monosodium glutamate and antioxidants in accordance with the chart of *
* substances in § 318.7(c)(4) of this subchapter. *

* (c) If Italian sausage products are cooked, determination of compliance *
* with the provisions of paragraphs (a) and (b) of this section shall be based *
* on the uncooked product. *

* NOTE: The provisions set forth in § 319.145 become effective December 31, 1976.*

Subpart F-Uncooked, Smoked Sausage

§ 319.160 Smoked pork sausage.

"Smoked Pork Sausage" is pork sausage that is smoked with hardwood or other approved nonresinous materials. It may be seasoned with condimental substances as permitted in Part 318 of this subchapter. It shall not be made with any lot of product which, in the aggregate, contains more than 50 percent

trimmable fat; that is, fat which can be removed by thorough practicable trimming and sorting. To facilitate chopping or mixing, water or ice may be used in an amount not to exceed 3 percent of the total ingredients used.

Subpart G-Cooked Sausage

§ 319.180 Frankfurter, frank, furter, hotdog, wiener, vienna, bologna, garlic bologna, knockwurst and similar products.

(a) Frankfurter, frank, furter, hotdog, wiener, vienna, bologna, garlic bologna, knockwurst and similar cooked sausages are comminuted, semi-solid sausages prepared from one or more kinds of raw skeletal muscle meat or raw skeletal muscle meat and raw or cooked poultry meat, and seasoned and cured, using one or more of the curing agents in accordance with § 318.7(c) of this chapter. They may or may not be smoked. The finished products shall not contain more than 30 percent fat. Water or ice, or both, may be used to facilitate chopping or mixing or to dissolve the curing ingredients but the sausage shall contain no more than 10 percent of added water. These sausage products may contain uncooked, cured pork from primal parts as defined in § 316.9(b) of this chapter, which do not contain any phosphates or contain only phosphates approved under Part 318 of this chapter. Such products may contain raw or cooked poultry meat not in excess of 15 percent of the total ingredients, excluding water, in the sausage. Such poultry meat ingredients shall be designated in the ingredient statement on the label of such sausage in accordance with the provisions of § 381.118 of this chapter.

(b) Frankfurter, frank, furter, hotdog, wiener, vienna, bologna, garlic bologna, knockwurst and similar cooked sausages that are labeled with the phrase "with byproducts" or "with variety meats" in the product name are comminuted, semi-solid sausages consisting of not less than 15 percent of one or more kinds of raw skeletal muscle meat with raw meat byproducts, or not less than 15 percent of one or more kinds of raw skeletal muscle meat with raw meat byproducts and raw or cooked poultry products; and seasoned and cured, using one or more of the curing ingredients in accordance with § 318.7(c) of this chapter. They may or may not be smoked. Partially defatted pork fatty tissue or partially defatted beef fatty tissue, or a combination of both, may be used in an amount not exceeding 15 percent of the meat and meat byproducts or meat, meat byproducts, and poultry products ingredients. The finished products shall not contain more than 30 percent fat. Water or ice, or both,

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